

Work Order ID 69284



Friday, May 06, 2011 11:34:35 AM

Page 1

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-5-10

FLOW CNC Waterjet

304 . 040

1-Cut as per Dwg D3535

 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B11-5-10

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69284

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Page 2

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Setup Start



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Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130

**Operation
Description**

NC BRAKE

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**Accept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Memo

0.00

Brake NC

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-
Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 69284

Page 3

Friday, May 06, 2011 11:34:35 AM

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC3- Inspect Part Finish

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

15 BL 11-512

170



Identify as per dwg & Stock Location:

FP-18

0.00

Packaging

Packaging

Memo

0.00

15 BL 11-512

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/5/13 MF

11-05-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:34:41 AM

Page 1

Work Order ID: 69284



Parent Item: D3535-25



Parent Item Name: Wearshoe

Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	115.7000	0.51	6.442105 		(B11-5-10)	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	115.7	
116623	0.2	
117550	115.5	117550

15

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	69284
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-16	Date:	11/05/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	 

W/O:		WORK ORDER CHANGES					
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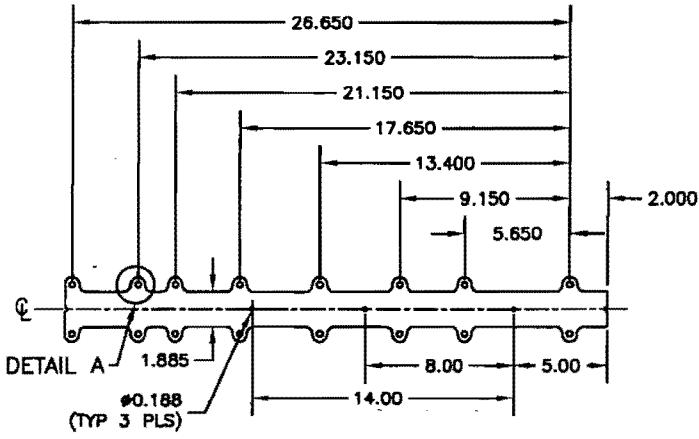
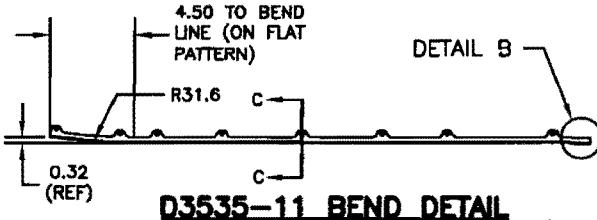
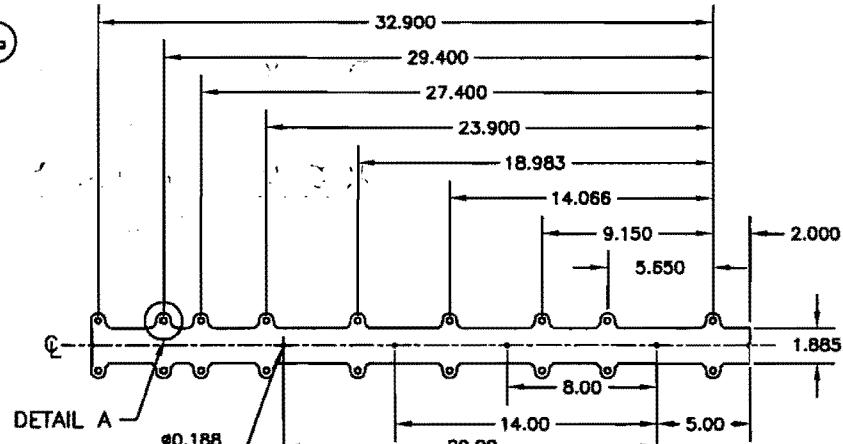
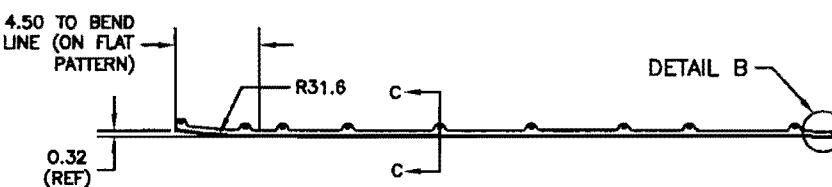
NOTE: Date & initial all entries

DART

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69284

RELEASED

07.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17		D3535	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

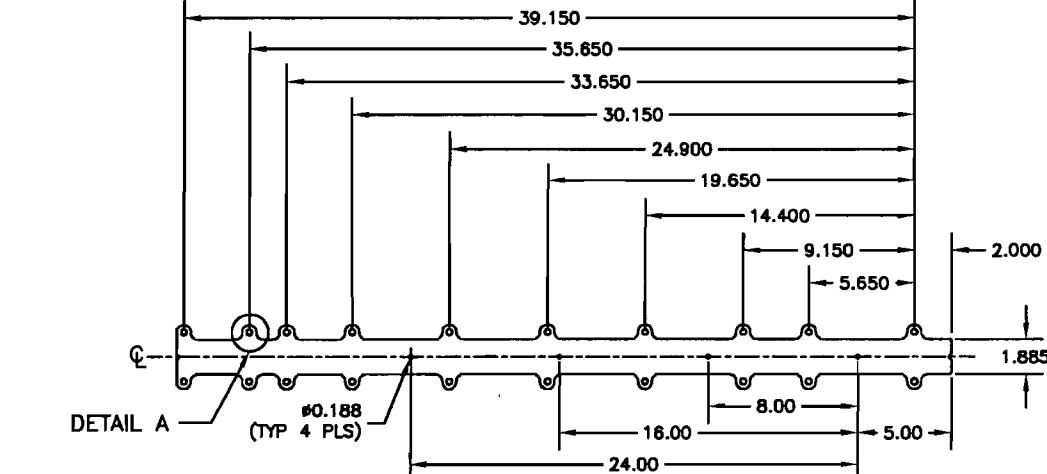
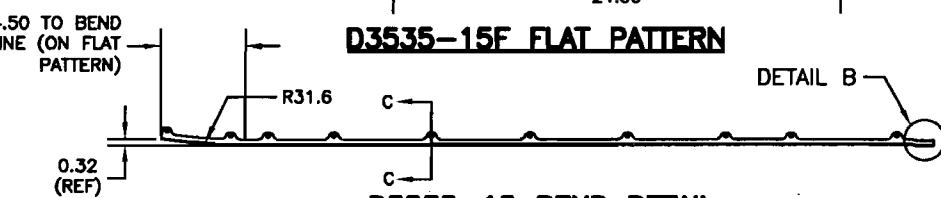
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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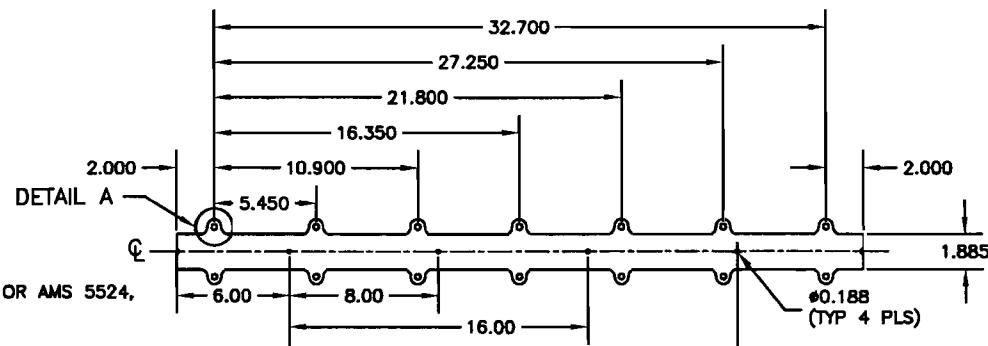
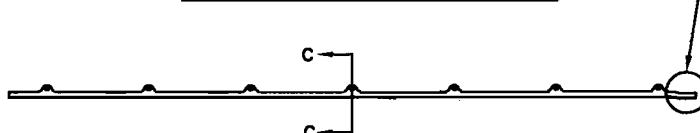
NOTE: Date & initial all entries

DARTRELEASED
07.04.17

DESIGN C8	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MF	APPROVED MF	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7 SCALE 1:10

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

WV69284

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

NOTES

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20 GAUGE (0.038 THICK)
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PAINT MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

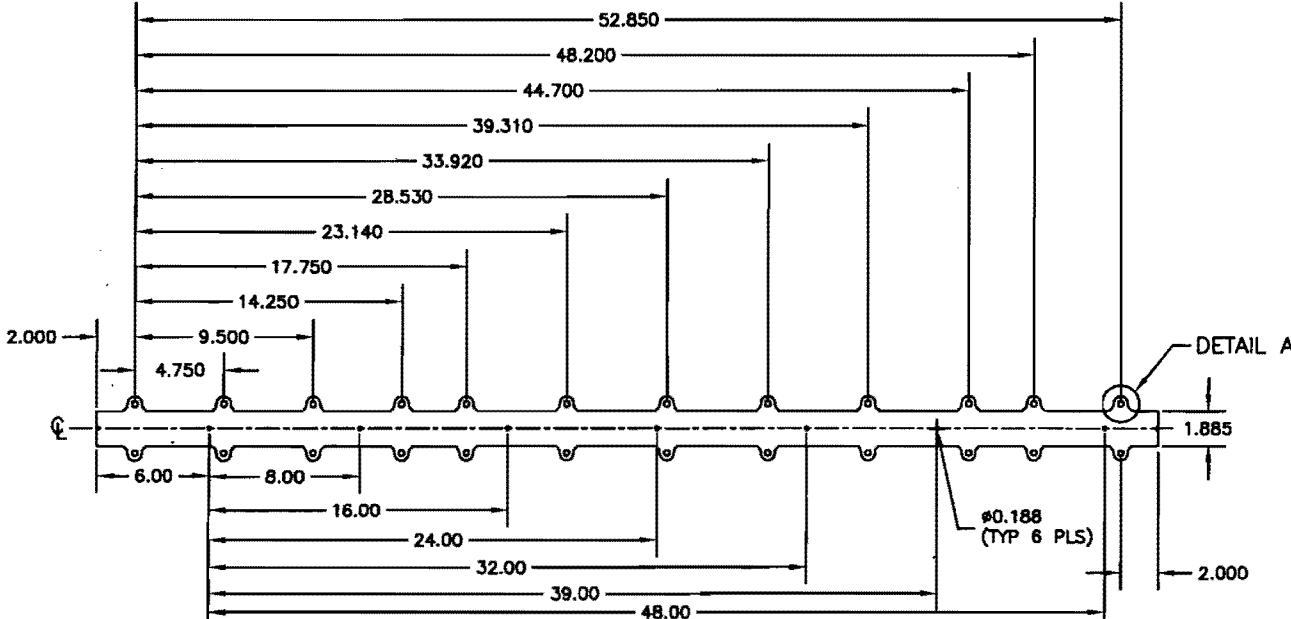
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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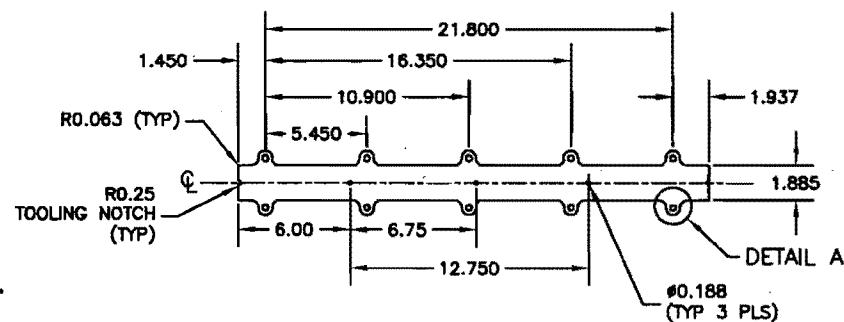
D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL

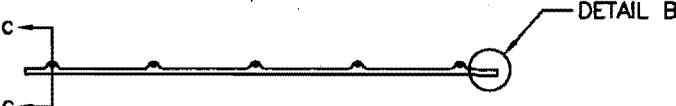
RELEASED
07.04.24

DART

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CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		REV. B SHEET 3 OF 7 SCALE 1:10



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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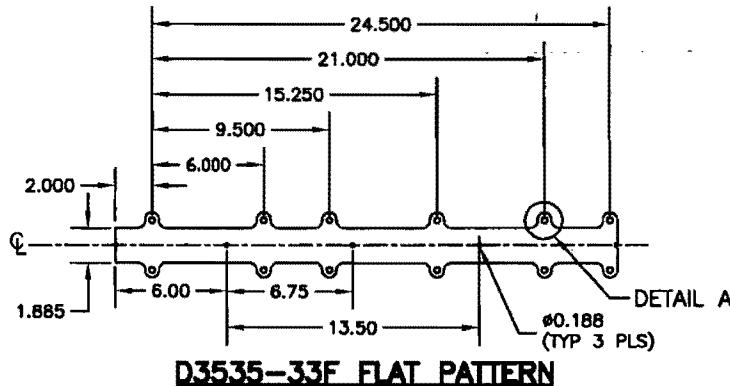
NOTE: Date & initial all entries

DART

DESIGN C8	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

RELEASED
07.04.17

W/069284

**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

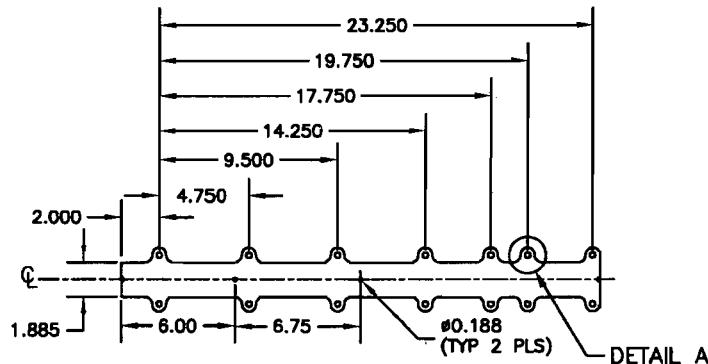
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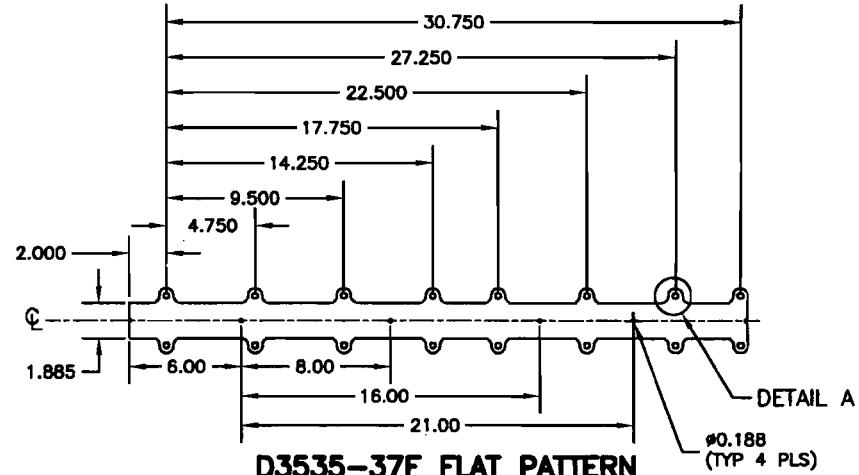
D3535-35F FLAT PATTERN



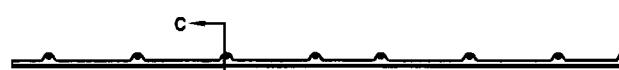
D3535-35 BEND DETAIL

NOTES

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D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

RELEASED
07.04.14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C8	MH	DRAWING NO. D3535
CHECKED	MH	DATE 07.04.17
APPROVED	MH	TIME WEARSHOE
		SCALE 1:10
		REV. B SHEET 5 OF 7

W/1069284

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

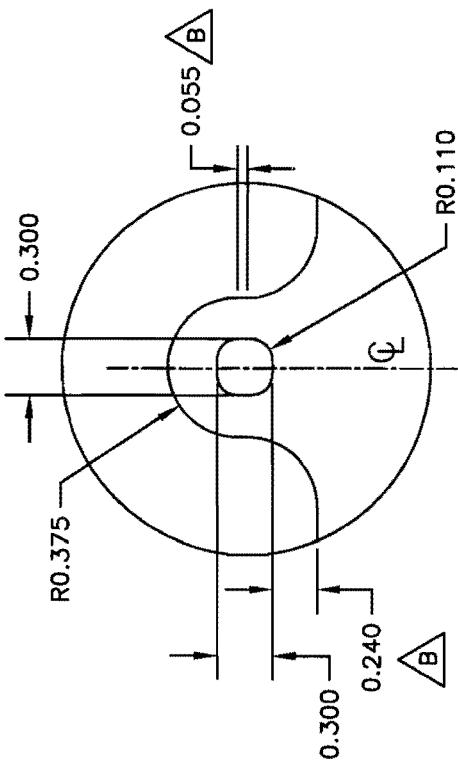
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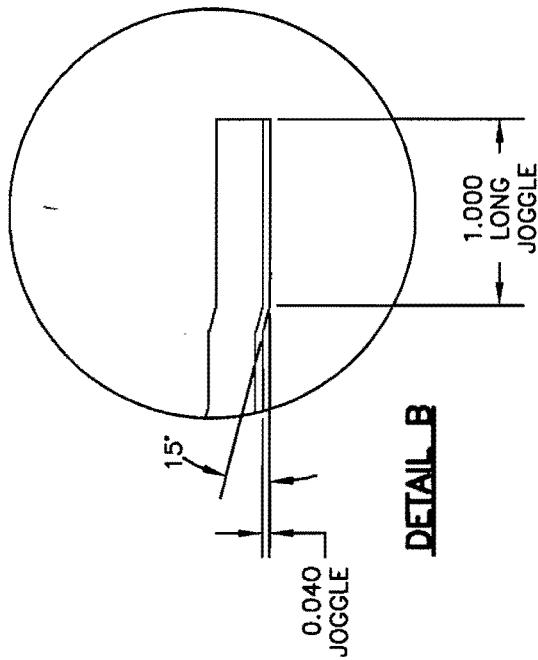
DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

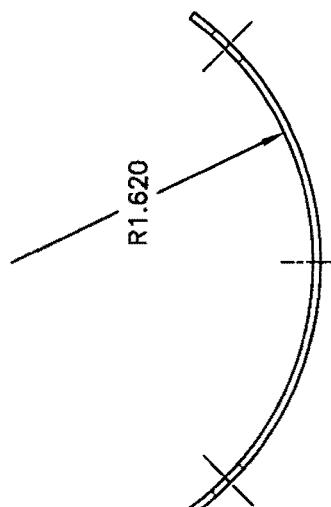
RELEASED

07.04.24 *[initials]*

DETAIL A



DETAIL B



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries